

**Aero Design Ltd.****Work Order Control Sheet**Work Order#: **2014-80** Date Opened: **16 Oct 2014** Title: **Assembly**Aircraft OEM: **Bell** Aircraft Model: **206L/407** Product Type: **Cargo Basket Body** Product Model: **Wide** Quantity: **1****Work Order Contents**

Work Order/Build Sheets (Procedures Provided)  
Additional Work Sheets (Standard Practice)  
Drawings (See List Below)  
Parts Distribution Sheet  
Sub Component Tags  
Completed Certification (Original)  
Time Sheet (R&D)  
Notes

Initial or N/A

JR
N/A
JR
JR
JR
N/A
N/A
N/A

**Build Sheet Contents**

Tasks Initialled  
Dual Inspections Initialled

Initial or N/A

JR
JR

**Drawing List**

Drawing #	Rev #	Description	Initial or N/A
94510	0	Basket	JR
94511	0	Body	JR
94521	0	Regular Mount Hoop	JR
94522	0	Aft Hoop	JR
94527	0	Data Plate	JR

**Component Completion**

Quantity Complete on This Work Order  
Quantity Incomplete on This Work Order  
Further Processing Required Before Release  
Release to Stock as Components

As Instructed

1
N/A
N/A
N/A

**Certification**

Form One Completed  
Serviceable (Green) Tag Completed  
In Process (Yellow) Tag Completed  
Unserviceable (Red) Tag Completed  
Parts Tracking (White) Tag Completed  
Parts Placed in Stores for Distribution

Initial or N/A

N/A
N/A
N/A
N/A
JR
JR

**Additional Documentation**

Documentation of a minor change  
Non-Conformance Report Required  
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

**Billing**

Local (Aero Design)  
Research and Development  
Third Party

Initial or N/A

JR
N/A
N/A

**Traveller**

Initial or N/A


Work performed by:

Print: J Rekve for M Rekve

Sign: 

SCA: AD01

Date: 31-Oct-14

ICC / Dual Inspection performed by:

Print: Jason Rekve

Sign: 

SCA: AD01

Date: 31-Oct-14

Work Order closed by:

Print: Jason Rekve

Sign: 

SCA: AD01

Date: 05-Nov-14

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014



## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 94521-01

Aircraft: Bell

Model: 407

Description: Forward Hoop

Supplier: Aero Design

Color: N/A

WO#: 2014-66

PO# 14060



## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 94522-01

Aircraft: Bell

Model: 407

Description: Low Mount AFT Hoop

Supplier: Aero Design

Color: N/A

WO#: 2014-66

PO# 14060

## CARGO BASKET BODY FABRICATION - COMMON

206L/407 WIDE XS size

### General

no 2014-80

all w/ cutout

These instructions apply to all cargo basket body assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

#### **Bell 206L/407** – Right side only

69811, Revision 3 – Standard Low Mounted Basket

→ 94511, Revision 0 – Extra-Wide Low Mounted Basket

94611, Revision 0 – Extra-Wide Low Mounted Ski Basket

76611, Revision 0 – High Mounted Ski Basket

Options 70404, Revision 2 – Front end cutout – 698

→ 70411, Revision 0 – Front end cutout – 945/946

#### **Eurocopter AS350/AS355** – left or right

77611, Revision 1 – Short Basket

76411, Revision 3 – Medium Basket (left or right)

78411, Revision 2 – Long Basket

94011, Revision 0 – Extra Large (ski) Basket

Options 70406, Revision 2 – Front end cutout – 764/776/784/940

#### **Robinson R44** – left or right

90611, Revision 0 – Standard Basket (left or right)

#### **Bell 206B** – right side only

80211, Revision 0 – Short Basket

80311, Revision 0 – Medium Basket

81111, Revision 0 – Long Basket

Options 70406, Revision 2 – Front end cutout – 802/803/811

#### **Bell 429** – right or left

95911, Revision 0 – Standard Basket

#### **Bell Medium** – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

Options 70407, Revision 1 – Front end cutout – 751

704, Revision – Front end cutout – 955

#### **MD600**

82811, Revision 0 – Standard Basket

#### **Options** – Applicable to all models

70403, Revision 5 – Auxiliary Latch



## CARGO BASKET BODY FABRICATION - COMMON

Complete  
(initial or SCA #)

Work Order: 2014-80

Date Open: Oct 2014

### 1. Rim Assembly – Basket Body

- a. Cut and fit  $\frac{3}{4}$ " x 0.035 material to fit rim jig.
  - i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
- b. Record material PO on attached material list.
- c. Remove writing on tubes with acetone and scotch bright.
- d. For extra large baskets – drill #30 (0.129) vent holes to vent stringer tubes into rims.
- e. 94611 (206L/407 XL ski) only – drill for 4 threaded bushings before assembling rim.

Previously c/w —

### 2. Weld Rim Assembly.

- a. Record welding rod PO on attached material list.
- b. 94611 (206L/407 XL ski) only – weld 4 threaded bushings into inboard rim tube.

AD-05

### 3. Inspection

- a. Rim for complete welds

OK

### 4. Frame assembly – body

- a. General
  - i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing, hoops, etc.)
- b. Grind corner welds from step 2 on rim to allow hoops to sit flat.
- c. Pull required hoops from stock - standard, attachment, handle.
  - i. If hoops are not in stock see detailed procedure sheet for specific hoop fabrication.
  - ii. Ensure vent hole is located at centre of tube to vent spine tubes.
- d. Assemble hoops with attachment lug locating jig and hoop spacing jig.
  - i. Ensure correct order and orientation of hoops. Refer to drawing.
    - 1. Attachment lugs are on inboard side.
    - 2. Handle bracket bushings are on outboard side, second hoop from both ends.  
May be on attachment hoops.
  - ii. Run 3/8-24 tap into attachment lugs to ensure clear threads.
  - iii. Bolt attachment lug locating jig to attachment hoops with 3/8-24 bolts.
  - iv. Attach inboard and outboard hoop spacing jigs to all hoops using 1" C-clamps. Raise jigs approximately 2" off table to allow room to weld around hoops.
  - v. Attach bottom (spine) jig to all hoops using 1" C-clamps along the centre line of the basket. Ensure jig is straight prior to tightening all clamps.
- e. Cut  $\frac{1}{2}$ " x 0.035 material to fit spine jig.
- f. Cut  $\frac{1}{2}$ " x 0.035 material for strut to fit from lower inboard attachment to upper outboard rim.
  - i. Refer to applicable drawing for position, not required on some baskets.
- g. Option: Cut  $\frac{1}{2}$ " x 0.035 material for front end cutout. Record material PO on attached material list.
- h. 90611 (R44) only: Cut  $\frac{1}{2}$ " x 0.035 material to fit front end structure. Record material PO on attached material list.
- i. Drill vent holes into attachment hoop and/or rim to vent strut(s) and front end cutout.

AD-05

- j. Record hoop WOs and material POs on attached material list.
- k. Remove writing on tubes with acetone and scotch bright.
- l. Insert rim assembly into jig and set frame assembly onto rim. Ensure correct orientation of lid prop bushings in rim to frame. Bushing hole must be closer to attachment side.
- m. Align hoops to rim in accordance with drawing. General positions:
  - i. Extra large baskets
    - 1. inboard side of hoops (attachment side) aligns to OUTSIDE of rim
    - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
    - 3. forward and aft hoops align to INSIDE of rim
  - ii. All other baskets
    - 1. inboard side of hoops (attachment side) aligns to INSIDE of rim
    - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
    - 3. forward and aft hoops align to INSIDE of rim, except R44

## 5. TIG weld frame to rim assembly.

AD-05

- a. Ensure lug locating jig and hoop locating jigs are in place. Jigs must remain in place for as long as practical during welding.
- b. Strut tubes and front end cutout (see step 4.f. and g.) must be welded in place after the hoops are welded to the rim. Jig(s) must be in place prior to welding strut tubes.
- c. Robinson R44 (90611) requires fitting and welding of forward end after remainder of basket frame is welded. Use jig to support front hoop.
- d. Record welding rod PO on attached material list.

## 6. Inspection

AD06

- a. Frame assembly for complete welds.

## 7. Mesh assembly.

AD06

- a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- b. Cut mesh to size for body.
- c. Remove surface rust with scotch-brite.
- d. Bend body mesh – use table with bend markings on top. Lock wheels on table.
  - i. For extra wide baskets only –
    - 1. Set  $\frac{3}{4}$ " angle along edge of table under mesh sheet. Set 1.5" square tube on top of mesh aligned with angle on edge of table. Clamp in place with 6" C-clamps.
    - 2. Bend upper edge of sheet just past a cell intersection to make a flange 2.5" - 3.25" wide. Closer to 2.5" is preferred, full cell intersection on flange side at bend is required.
    - 3. Bend down by hand as far as possible, then use a hammer to flatten the bend tight against the angle on the edge of the table.
  - ii. Using markings on table, align sheet to indicated edge.
  - iii. Using markings on table, align 3" tube to required position and clamp tube in place.
  - iv. Bend mesh by hand tightly over tube along length of tube.
  - v. Keeping mesh in place, un-clamp 3" tube, move to other position and clamp tube in place.
  - vi. Bend mesh by hand tightly over tube along length of tube.
- e. Install attachment lug jig onto basket frame.



- f. Ensure end struts are welded in basket frame if required by the drawing.
- g. Insert mesh into basket.
  - i. General
    - 1. Some cells may interfere with correct positioning, especially at the upper corners and around struts. Bend cell(s) in as required, do not cut cells off.
    - 2. Ideally welds will be located on mesh intersections. Shift mesh if possible to minimize welds located off mesh intersections.
    - 3. Ensure mesh reaches all edges of basket BEFORE trimming. Regardless of progress in clamping, remove clamps and shift mesh if required.
    - 4. Ensure cleco clamps are placed from the inside of the basket to allow removal during welding. Cleco clamps may be used from the outside during fitting, but must be removed prior to welding.
  - ii. Extra large baskets only – seat corner of mesh with flange into inboard upper corner of frame. Use C-clamps on edge of flange as required to maintain tight fit.
  - iii. Starting at inboard top edge of basket, clamp mesh to hoop near top rim using cleco clamps onto hoops. For regular size baskets, edge of mesh should sit approximately half way up rim tube.
  - iv. Working down the inboard side, clamp mesh to hoops with cleco clamps. Clamp down into radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, two clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
  - v. Clamp mesh to spine in at least 1 place per section.
  - vi. Working up the outboard side, clamp the mesh into the radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, 2 clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
  - vii. Trim upper outboard edge of mesh if required, edge of mesh must be low enough on rim tube to prevent the weld from protruding above the edge of the rim. Some sheets are tapered and may require  $\frac{1}{2}$  to 1 cell to be removed over some or all of the length of the basket. De-burr cut edges with a sanding disc on a die-grinder. Straighten cut cells with duck-bill pliers. Clamp mesh near upper edge to hoops with cleco clamps after trimming.
  - viii. Trim ends to land on hoops, at mesh intersections if possible.
- h. Cut mesh to fit ends. Record material PO on attached material list.
  - i. Remove surface rust with scotch-brite.
  - ii. Ensure mesh is cut at intersections where possible.
  - iii. Bend top edge of mesh  $\frac{1}{8}$ "- $\frac{3}{16}$ " down at 45 degrees
  - iv. Cut for front end cutout if required.
- i. 90611 (R44) only: Cut mesh to fit upper forward end. Record material PO on attached material list.
  - i. Remove surface rust with scotch-brite.
  - ii. Ensure mesh is cut at intersections where possible.
  - iii. Bend top edge of mesh  $\frac{1}{4}$ " down at 60 degrees.
  - iv. Fit mesh to front end of basket.

## CARGO BASKET BODY FABRICATION - COMMON

Complete  
(initial or SCA #)  
AD-05

8. Weld mesh to frame assembly per drawing.
  - a. Ensure lug locating jig is in place prior to welding.
  - b. General welding requirements for all baskets, MIG welding:
    - i. Every intersection at top edges.
    - ii. Every intersection at ends.
    - iii. First 5 intersections down on hoops, then every second intersection.
    - iv. Every intersection along spine.
    - v. Extra large baskets – every intersection along corner.
    - vi. Every intersection around ends
    - vii. Every intersection along struts (if applicable)
  - c. Bend and trim cells bent in to fit mesh as required and weld in position.
  - d. Grind high spots off body mesh welds on ends before welding end mesh.
  - e. 90611 (R44) only – weld lid prop bushing (step 9) into rim BEFORE welding upper mesh on forward end of basket assembly.
  - f. Record welding rod PO on attached material list.

### 9. Weld basket components

- a. TIG weld lid prop bushing(s), one or two per drawing.
  - i. Record welding rod PO on attached material list.
  - ii. Record lip prop bushing WO on attached material list.
- b. TIG weld caps to close top of 1" hoops as applicable.
- c. 94611 (Bell206L/407 XL ski) only: cut rim over cross tube gap.
  - i. Cut inboard rim on aft end. Grind flush with hoops.
  - ii. TIG weld caps on open tubes.
  - iii. Record cap material PO on attached material list.
- d. 95911 (Bell 429) only: placard bracket to forward upper corner of basket.
  - i. Record welding rod PO on attached material list.
  - ii. Record placard bracket WO on attached material list.

### 10. Clean up

- a. Grind high spots off mesh welds.
- b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out. Do not tighten in corners of hoops, mesh will be deformed.
- c. Drill #9 through lid prop bushing(s). De-burr hole(s).
- d. Remove surface rust with scotch-brite pad.

### 11. Final Inspection

To be completed by a different person than the previous steps.

- a. Basket body assembly for complete welds, and required minimum mesh weld locations.
- b. Filled vent holes – usually on hoops
- c. Overall condition and conformity to drawing(s).
  - i. Hoops for height.
  - ii. Rim for width and length and alignment.
  - iii. Lid prop lugs in correct ends.
  - iv. Fore/aft strut in hoop if required by drawing.
- d. Material lists complete.



## CARGO BASKET BODY FABRICATION - COMMON

**Complete**  
(initial or SCA #)



- e. Tag complete basket body assembly in preparation for powder coating.

### 12. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag basket body assembly and place into stock in preparation for assembly.

Work Order: 2014-80

## Material Tracking Sheet

1 of 2

Bell 206L / 407

Date Opened: \_\_\_\_\_

Extra Wide Basket Body Fabrication

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>		<b>94511-01</b>	<b>Basket Assembly</b>		
<b>Step 1</b>				<i>Rim Assembly</i>		<i>WO# 2014-58</i>
	. 2		--	3/4" Tube - Long Rim (75.75")	4130 Steel, 3/4" x 0.035 Sqr. Tube	
	. 2		--	3/4" Tube - Short Rim (25.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	
	. 1		--	3/4" Tube - Long stringer (74.25")	4130 Steel, 3/4" x 0.035 Sqr. Tube	
	. 3		--	3/4" Tube - Short stringer (2.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	
<b>Step 2</b>				<i>Weld Rim Assembly</i>		
	A/R		--	Welding Rod	ER70S-2 TIG Rod	<i>PO# 14033</i>
<b>Step 3</b>				<i>Inspection - Rim</i>	None	
<b>Step 4</b>				<i>Frame Assembly</i>		
	. 1		94520-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	<i>see attached</i>
	. 2	84262	94520-01	Hoop - with handle provisions	4130 Steel, 1/2" x 0.035 Sqr. Tube	<i>see attached</i>
	. 1		94521-01	Forward Attachment Hoop		<i>see attached</i>
	. 1		94522-01	Aft Attachment hoop		<i>see attached</i>
	. 4		--	1/2" Tube - spine	4130 Steel, 1/2" x 0.035 Sqr. Tube	<i>14009</i>
	. 2		--	1/2" Tube - strut	4130 Steel, 1/2" x 0.035 Sqr. Tube	<i>14009</i>
<b>Step 4.g.</b>		70411	70411-01	Option: Front End Cutout		
			70411-03	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	<i>14009</i>
			70411-04	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	<i>14009</i>
<b>Step 5</b>				<i>Weld Frame Assembly</i>		
	A/R		--	Welding Rod	ER70S-2 TIG Rod	<i>PO# 14033</i>
<b>Step 6</b>				<i>Inspection - Frame Assembly</i>	None	

Work Order: 2014-80

## Material Tracking Sheet

2 of 2

Bell 206L / 407

Date Opened: \_\_\_\_\_

Extra Wide Basket Body Fabrication

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
<b>Step 7</b>				<i>Mesh Assembly</i>		
	. 1		--	Mesh (Body - 56" x 75")	3/4-16F Expanded Mild Steel sheet	14012
	. 2		--	Mesh (End - 24.75" x 16.75")	3/4-16F Expanded Mild Steel sheet	14012
<b>Step 8</b>				<i>Weld Mesh</i>		
	. A/R		--	Welding Rod	ER70S-6 MIG Wire	14019
<b>Step 9</b>				<i>Weld Basket Components</i>		
	. 1		49215-01	Spacer (Lid prop)	304 Stainless Steel, 1/2" Dia.	2013-55
	. A/R		--	Welding Rod	ER308L TIG Rod	14028
<b>Step 10</b>				<i>Clean Up</i>	None	
<b>Step 11</b>				<i>Inspection - Final Assembly</i>	None	
<b>Step 12</b>				<i>Powder Coating</i>		



Work Order: 2014-80Material Tracking Sheet  
Bell 206L / 407  
Extra Wide Hoops Fabrication

1 of 2

Date Opened: \_\_\_\_\_

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 1			94520-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	1410
Step 1			94520-01	Hoop - with handle provisions	4130 Steel, 1/2" x 0.035 Sqr. Tube	14005
Step 2		84262		Welding		
	. 2		84272-01	Bushing	4130 Steel, 5/16" x 0.058 Rnd. Tube	2014-26
	A/R		--	Welding Rod	ER70S-2	14033
Step 3				Inspection	None	
			94521-01	Hoop - attachment (forward)		
Step 1				Fabrication		2014-26
	. 1		94520-01	1/2" Tube - hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	1410
Step 2				Welding		
	. 2		69823-02	Lug	1018 Steel, 5/8" Rod	
	A/R		--	Welding Rod	ER70S-2	
Step 3				Inspection and Finishing	None	

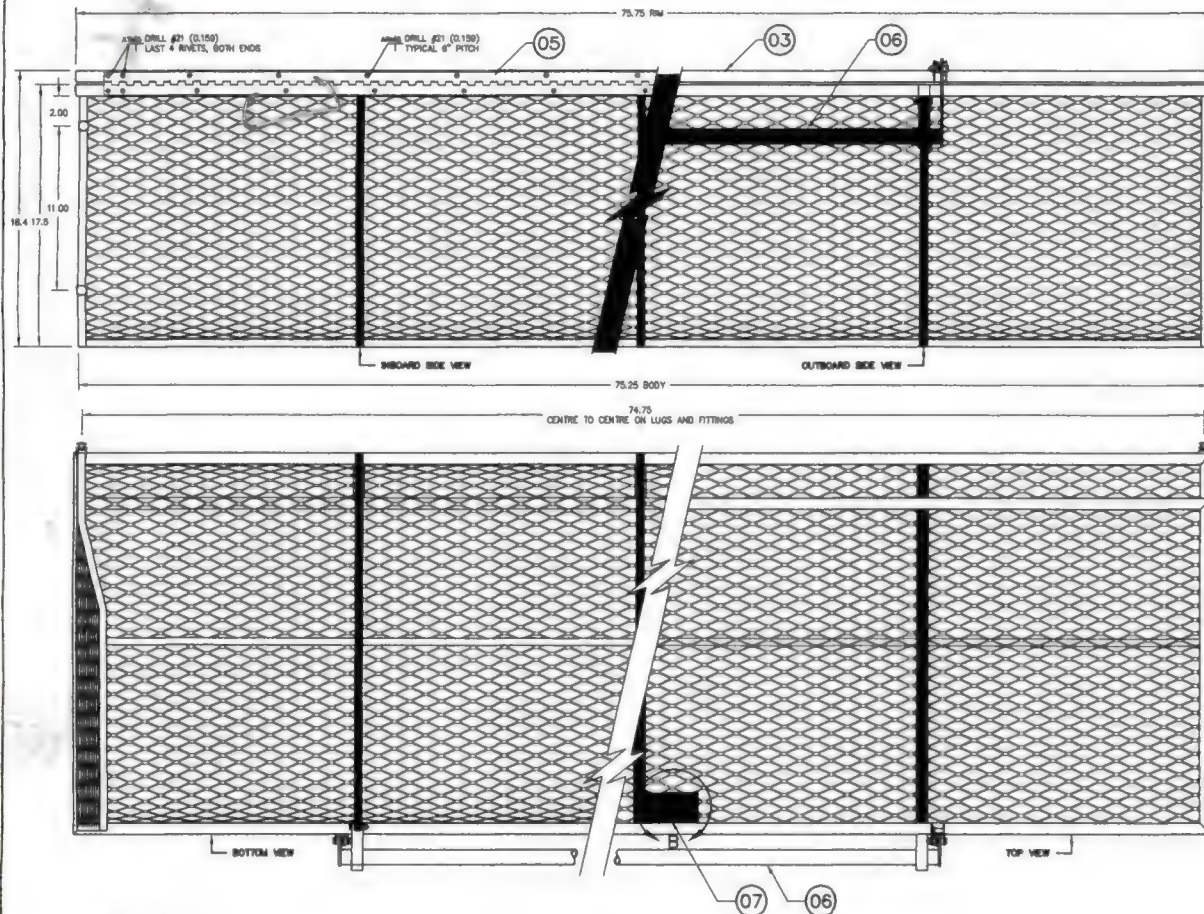
Work Order: 2014-80Material Tracking Sheet  
Bell 206L / 407  
Extra Wide Hoops Fabrication

2 of 2

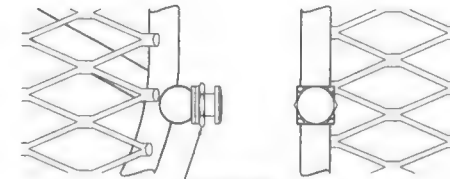
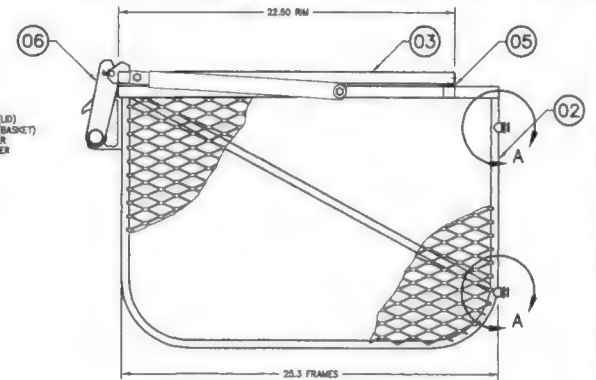
Date Opened: \_\_\_\_\_

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
			94522-01	Hoop - attachment (aft)		
Step 1				Fabrication		
	. 1		--	1/2" Tube - hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	2014-80 66 OK
Step 2				Welding		
	. 2		69823-02	Lug	1018 Steel, 5/8" Rod	
	. A/R		--	Welding Rod	ER70S-2	
Step 3				Inspection and Finishing	None	

2014-80 x518



REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	CREATED FROM 89810, REV. 3		

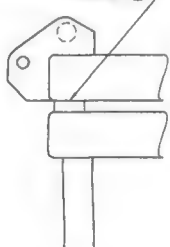


DETAIL A

SCALE 1 : 1  
LOOKING AT LOWER ATTACHMENT, UPPER ATTACHMENT SIMILAR  
TYPICAL FRONT AND REAR

NOTE:  
1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.

DRILL 0.25 INTO LUG  
ENSURE CLEARANCE FROM MESH  
3 PLACES MIN



BUMPER INSTALLATION  
SCALE 1 : 1

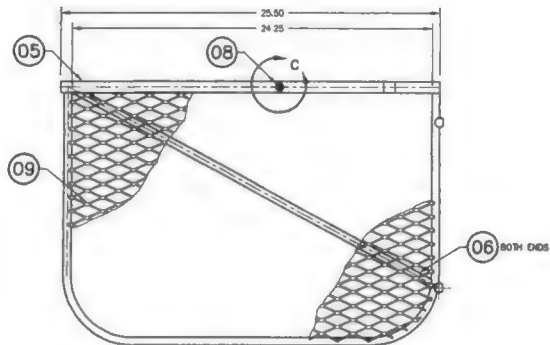
01 CARGO BASKET ASSEMBLY



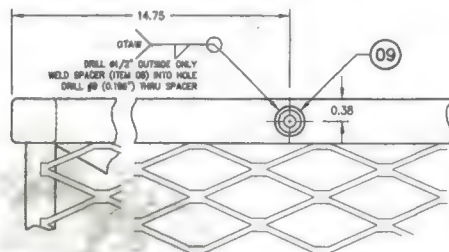
A/R	AN800-016	WASHER				
4	40088-14	FITTING	ANORA			
4	CR3213-4-02	CHEVY RIVET				
8	CR3213-5-02	CHEVY RIVET				
A/R	CR3213-3-02	CHEVY RIVET				
3	49205-14	BUMPER	ARQUE INDUSTRIES			
1	94527-01	PLACARD				
1	84255-01	HANDLE BAR INSTALLATION				
1	MS2000P4	PIANO HINGE			5 FEET LONG	
1	36260-01	BRACE ASSEMBLY				
1	89812-01	LD ASSEMBLY				
1	84211-01	BASKET BODY ASSEMBLY				
1	94510-01	CARGO BASKET ASSEMBLY				
D1	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

BASIC CODE REF. HAS 583	DASH NO. FOR DIAMETER N=MPD. HEAD NEAR SIDE F=MPD. HEAD FAR SIDE	APPROVALS JEFF CLARKE	DATE 15 SEPT 2011	<b>AERO DESIGN LTD.</b> CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAB 890M 5015 - 50TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2B 6R7 Tel: (403) 280-0027 Fax: (403) 280-0023 aerodesign@aerobasket.net		
C-COUNTERSINK D=DIMPLE DIGIT# OF SHEETS TO BE DIMPLED	DASH NO. FOR LENGTH	CHECKED: E. BURGOIN				
BASIC CODES: BJ=MS20470AD BB=MS20426AD ARM=CR3213 ATM=CR3523	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1			BELL 206L SERIES, 407 QUICK RELEASE CARGO BASKET CARGO BASKET ASSEMBLY		
⊕ INSTALL NEW RIVET				SCALE 1 : 4		
⊕ REMOVE/REPLACE RIVET				SHEET 1 OF 1		
⊖ EXISTING RIVET				A1	94510 0	



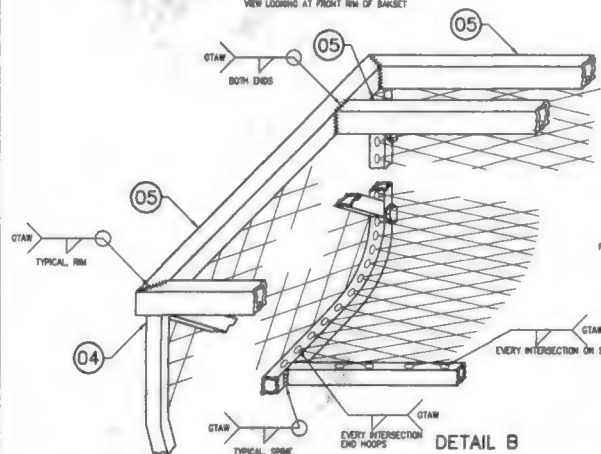


- NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
  2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AWS D8.85C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
  3. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
  4. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY.

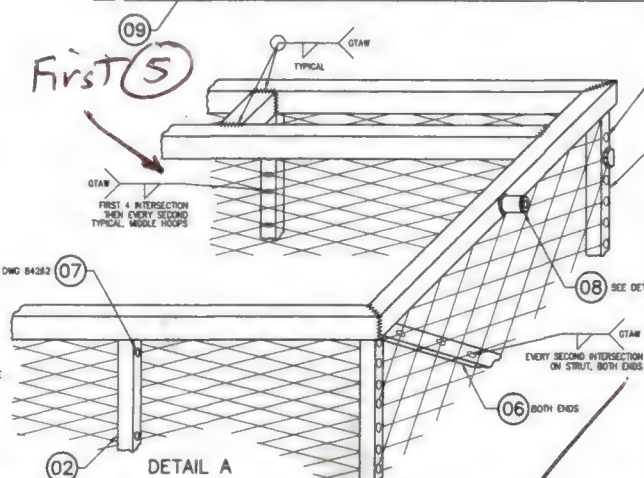
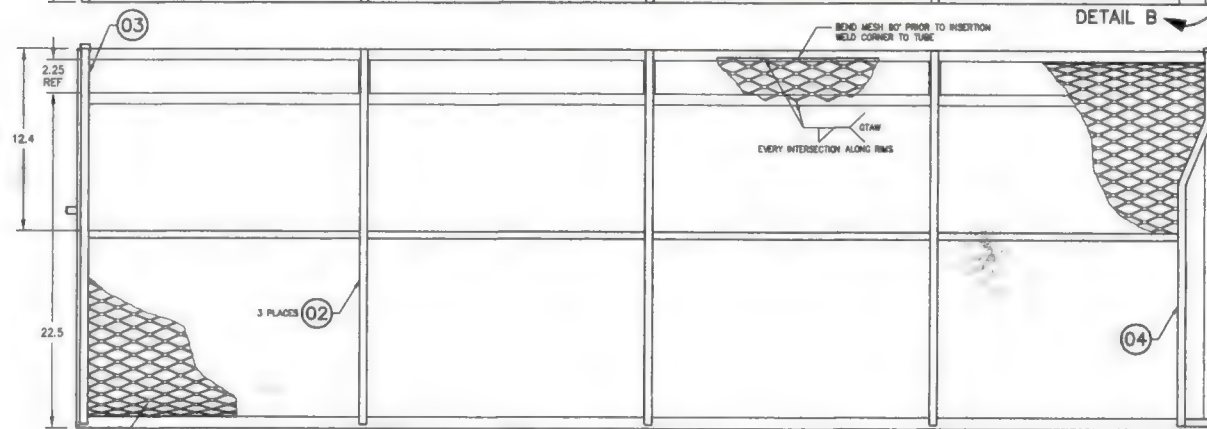
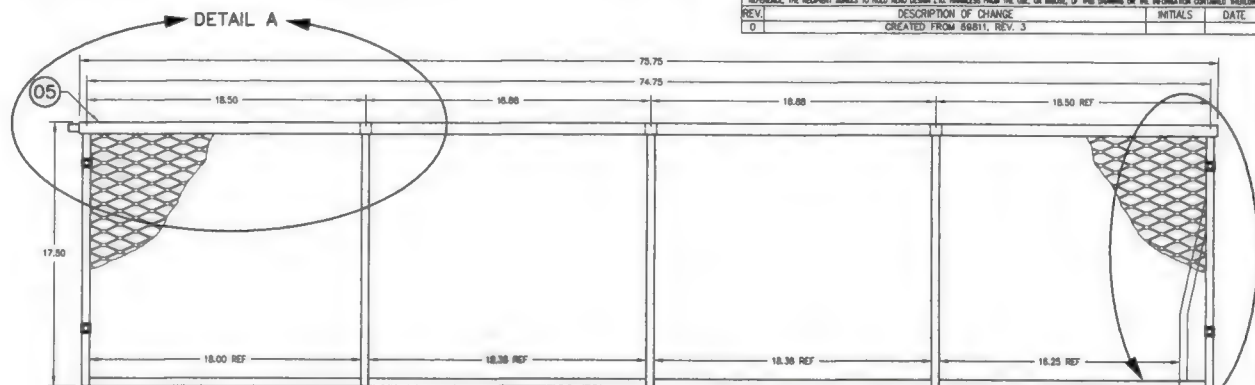


DETAIL C

SCALE 1:1  
VIEW LOOKING AT FRONT RIM OF BASKET



DETAIL B

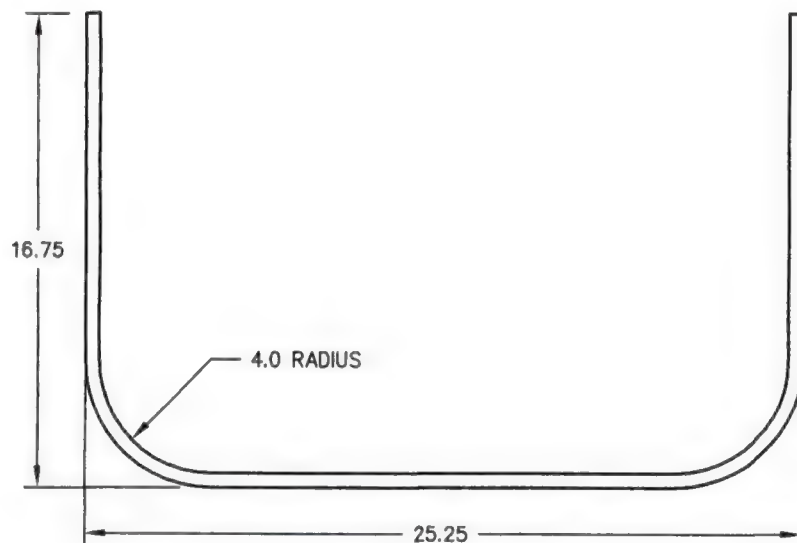


DETAIL A

01 BASKET BODY ASSEMBLY

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	42215-01	08	SPACER	STEEL	COMMERCIAL	
1	84282-01	07	HANDLE BRACKET ASSEMBLY			
1	---	06	TUBE	4130 STEEL, COND. H	MIL-T-6738	0.5 X 0.035 SQR. TUBE
1	---	05	TUBE	4130 STEEL, COND. H	MIL-T-6738	0.75 X 0.035 SQR. TUBE
1	84522-01	04	LEFT END HOOP			
1	84521-01	03	FORWARD END HOOP			
3	84520-01	02	HOOP			
1	84511-01	01	BASKET BODY ASSEMBLY			
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	---	08	SPACER	STEEL	COMMERCIAL	
1	---	06	TUBE	4130 STEEL, COND. H	MIL-T-6738	0.5 X 0.035 SQR. TUBE
1	---	05	TUBE	4130 STEEL, COND. H	MIL-T-6738	0.75 X 0.035 SQR. TUBE
1	---	04	LEFT END HOOP			
1	---	03	FORWARD END HOOP			
3	---	02	HOOP			
1	---	01	BASKET BODY ASSEMBLY			

\* Every Intersection or crossing



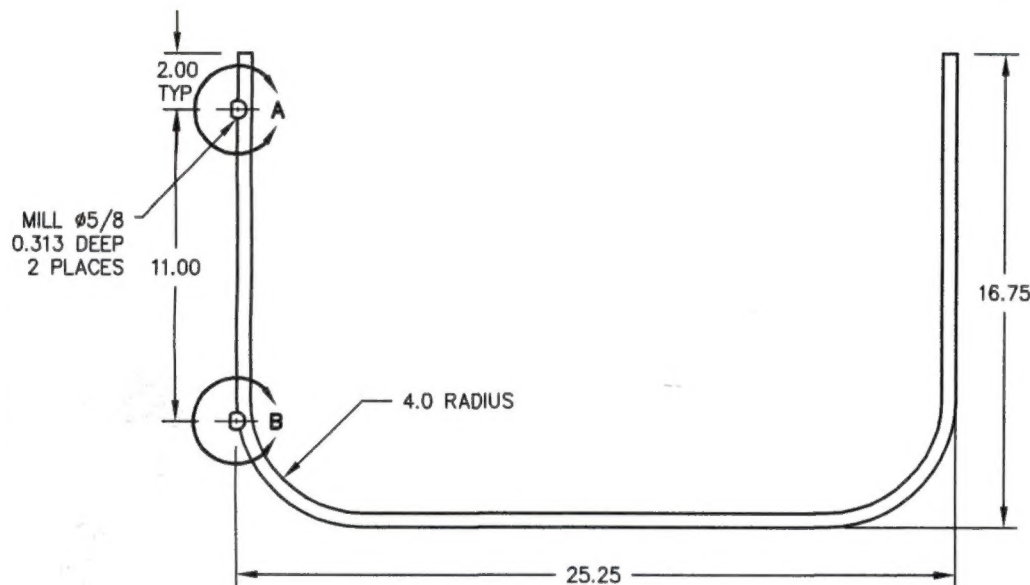
01 HOOP

NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.
2. DRILL 3/32" VENT HOLE IN BOTTOM OF HOOPS FOR VENTING WELD GASES.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0			

	94520-01	01	END HOOP	4130 STEEL COND. N	MIL-T-6736	1/2 x 0.035 SQR. TUBE		
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE		
QTY	LIST OF MATERIALS							
THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THE DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DISCLOSED IN ANY MANNER AND USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.	APPROVALS		DATE		<b>AERO DESIGN LTD.</b> CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8087 fax: (403) 250-8333 www.aerodesign.ca			
	DRAWN: JEFF CLARKE		13 SEPT 2011					
	CHECKED: E. BURGOIN							
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:				<b>BELL 206L SERIES, 407</b> <b>QUICK RELEASE CARGO BASKET</b> <b>HOOP</b>			
	DECIMALS		ANGLES					
	X.XXX ±0.010		±1/2°					
X.XX ±0.03				SCALE 1 : 5		DWG. SIZE	DWG. NO.	REV.
X.X ±0.1				SHEET 1 OF 1		LGL	94520	0

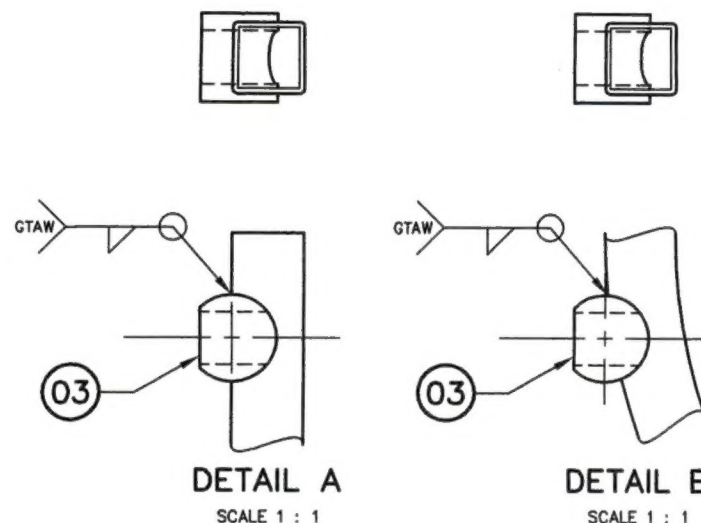


**01 FORWARD HOOP**

**NOTES:**

1. REMOVE ALL BURRS AND SHARP EDGES.
2. DRILL 3/32" VENT HOLE IN BOTTOM OF HOOPS FOR VENTING WELD GASES.
3. WELDING OF LUGS TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0			

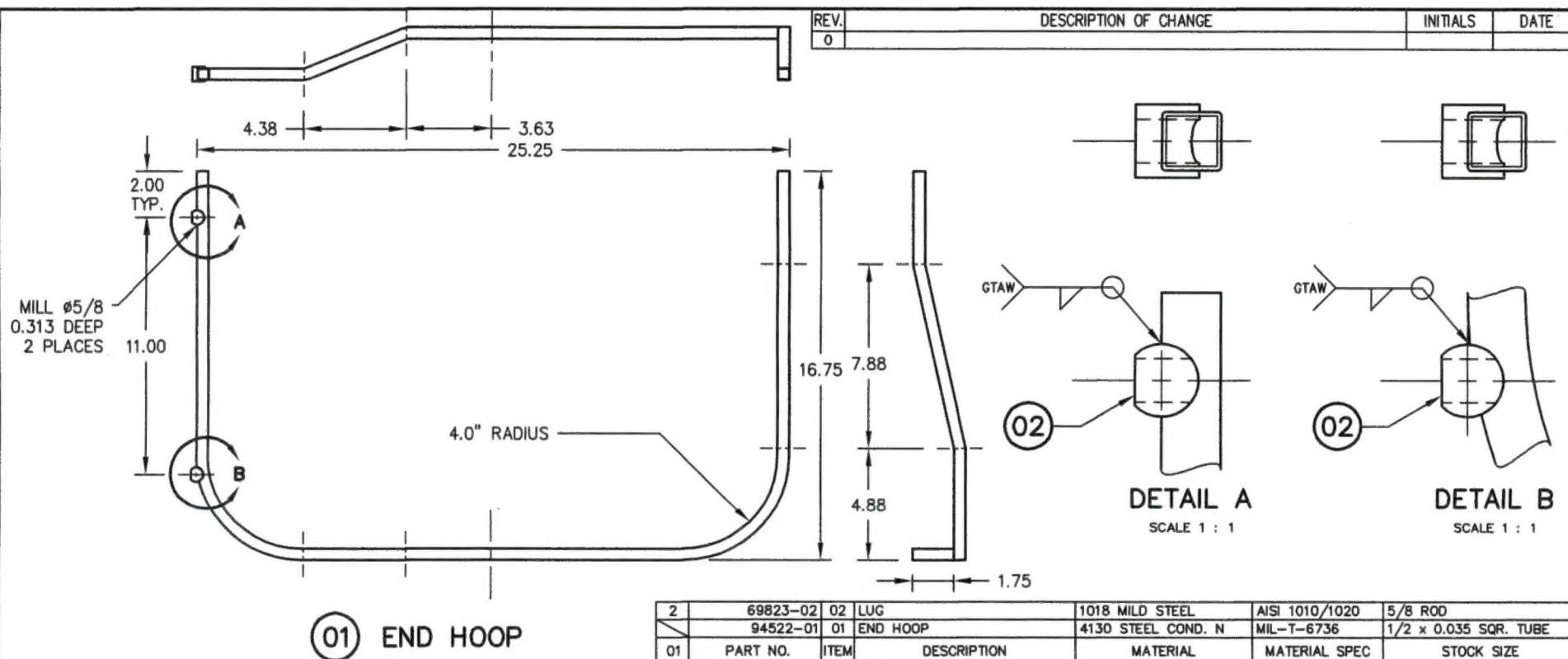


2	69823-02	02	LUG	1018 MILD STEEL	ISI 1010/1020	5/8 ROD
	94521-01	01	FORWARD HOOP	4130 STEEL COND. N	MIL-T-6736	1/2 x 0.035 SQR. TUBE
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

**LIST OF MATERIALS**

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	DRAWN: JEFF CLARKE		13 SEPT 2011					
	CHECKED: E. BURGON				<div><div>BELL 206L SERIES, 407</div><div>QUICK RELEASE CARGO BASKET</div><div>FORWARD HOOP</div></div>			
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:							
DECIMALS		ANGLES						
X.XXX ±0.010		±1/2°						
X.XX ±0.03								
X.X ±0.1								
SCALE 1 : 5		DWG. SIZE		DWG. NO.		REV.		
SHEET 1 OF 1		LGL		94521		0		





# NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. DRILL 3/32 VENT HOLE IN BOTTOM OF HOOP FOR VENTING OF WELD GASES
3. WELDING OF LUGS TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.

2	69823-02	02	LUG	1018 MILD STEEL	ISI 1010/1020	5/8 ROD
	94522-01	01	END HOOP	4130 STEEL COND. N	MIL-T-6736	1/2 x 0.035 SQR. TUBE
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

<div>THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECEPT AGREEES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.</div>	<div>APPROVALS</div>		<div>DATE</div>		<div>AERO DESIGN LTD.</div>			
	<div>DRAWN: JEFF CLARKE</div>		<div>13 SEPT 2011</div>		<div>CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M</div>			
	<div>CHECKED: E. BURGOIN</div>				<div>2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7</div>			
					<div>tel: (403) 250-8027 fax: (403) 250-8333 aerodesign@telusplanet.net</div>			
<div>NOTICE</div>	<div>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.</div>				<div>BELL 206L SERIES, 407</div>			
	<div>TOLERANCES ON:</div>				<div>QUICK RELEASE CARGO BASKET</div>			
	<div>DECIMALS</div>		<div>ANGLES</div>		<div>AFT HOOP</div>			
	<div>X.XXX ±0.010</div>		<div>±1/2"</div>					
	<div>X.XX ±0.03</div>				<div>SCALE 1 : 5</div>	<div>DWG. SIZE</div>	<div>DWG. NO.</div>	<div>REV.</div>
	<div>X.X ±0.1</div>				<div>SHEET 1 OF 1</div>	<div>LGL</div>	<div>94522</div>	<div>0</div>

# NOTICE

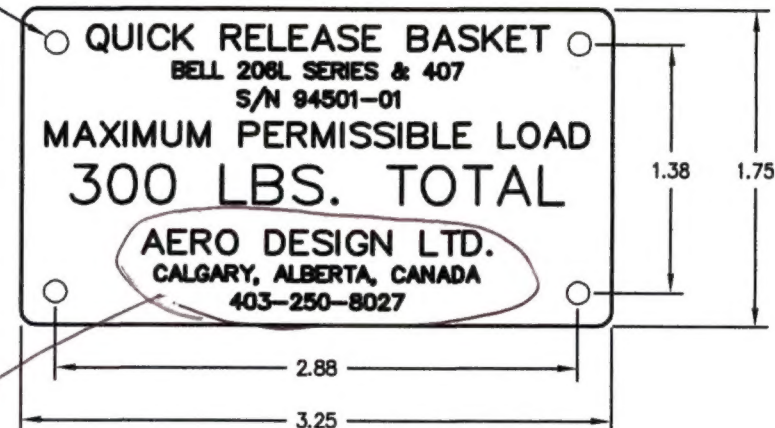
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	ORIGINAL ISSUE		

## NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:  
 "QUICK RELEASE BASKET" - 0.125 HIGH  
 "BELL 206L SERIES & 407" - 0.080 HIGH  
 "S/N 94501-XX" - 0.080 HIGH  
 "MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH  
 "300 LBS. TOTAL" - 0.200 HIGH  
 "AERO DESIGN LTD." - 0.125 HIGH  
 "CALGARY, ALBERTA, CANADA" - 0.080 HIGH  
 "403-250-8027" - 0.080 HIGH

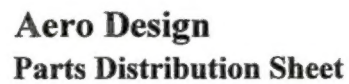
DRILL #30 (0.129)  
4 PLACES



?

01 PLACARD

1	94527-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					
			APPROVALS	DATE	<b>AERO DESIGN LTD.</b> CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027      fax: (403) 250-8333      aerodesign@telusplanet.net	
			DRAWN: JEFF CLARKE	16 SEPT 2011		
			CHECKED: E. BURGAIN			
			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS                      ANGLES X.XXX    ±0.010                      ±1/2" X.XX     ±0.03 X.X      ±0.1		BELL 206L SERIES, 407 QUICK RELEASE CARGO BASKET PLACARD	
			SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
			SHEET 1 OF 1	A1	94527	0



WO# 2014-80

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013